



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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C60-C

Job Sheet 204001



Part No: C60-C

Job Qty: 1 pcs

Part Name: Single Cage



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/2/19

Job Tracking No:

Due Date: 1/7/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: C60-C REV.D IPP REV:A 18.02.02 NEW ISSUE DD VERF:JFSDWG C60-C Rev D IPP Rev. A 19.03.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
100	External Load - Issue SN	1 pcs	1/7/20	0.00	0.50		External Load - 1		AP 2019-12-18
							External Load - 2		Made 2019-12-17
							External Load - 3		
110	External Load - 2 - B4B	1 pcs	1/7/20	0.00	0.50		External Load - 1 - B4B		AP 2019-12-18
							External Load - 2 - B4B		
							External Load - 3 - B4B		
120	QC 5	1 pcs	1/7/20	0.00	0.00		QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		DAS 58 JAN 07 2020
							QC 5 - 68		9-89
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	1/7/20	0.00	0.00		Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



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Container No: S241408



Part: C60 - C
Job No: 204001
Serial No/Batch: S241408
Revision: D
Inspector:
Exp Date:
Instructions:

Date: 12/17/19

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				Packaging 3 - 6 - B4B	DAS 58 JAN 07 2020
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	1/7/20	0.00 0.00	QC 21 - SA - 21	DAS 21 JAN 07 2020
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - Issue S/N

Descriptions: 110 - (Small Fab) ASSEMBLE AS PER DWG ***HAND TIGHT ALL BOLTS, SPREAD CUTTER PIN JUST ENOUGH THAT IT THOSE NOT FALL OFF***

120 - QC5- Inspect part completeness to step on W/O

130 - (Identify as per dwg & Stock Location:_____)

140 - (QC21- Final Inspection - Work Order Release)

CORNER

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
AN12H32	Bolt	1 pcs (1 ea)	100-External Load - Issue SN	5159804
91257A750	Cage Bolt	2 pcs (2 ea)	110-External Load - 2 - B4B	5179085
AN310-12	Castellated Nut	1 pcs (1 ea)	110-External Load - 2 - B4B	5004855
C45-15-10	Ford Bumper	1 pcs (1 ea)	110-External Load - 2 - B4B	5209453
C45-15-11	Nut, Cage Bumper	1 Ea (1 ea)	110-External Load - 2 - B4B	5085248
C45-15-5	Nut, Cage Bolt	2 Ea (2 ea)	110-External Load - 2 - B4B	5189667
C45-15-6	Bushing, Lifting	1 pcs (1 ea)	110-External Load - 2 - B4B	5180462
C45-15-7	Washer, Lifting Bolt	4 pcs (4 ea)	110-External Load - 2 - B4B	5175984
C45-18-7	Shim	4 Ea (4 ea)	110-External Load - 2 - B4B	5189687
C60-19C	Weldment	1 pcs (1 ea)	110-External Load - 2 - B4B	5184959
MS24665-363	Cotter Pin	1 Ea (1 ea)	110-External Load - 2 - B4B	5092509
NAS1149C0663R	Washer (AN960C616)	1 Ea (1 ea)	110-External Load - 2 - B4B	5076016-1
NAS1149F0863P	Washer (AN960-816)	4 Ea (4 ea)	110-External Load - 2 - B4B	5058169

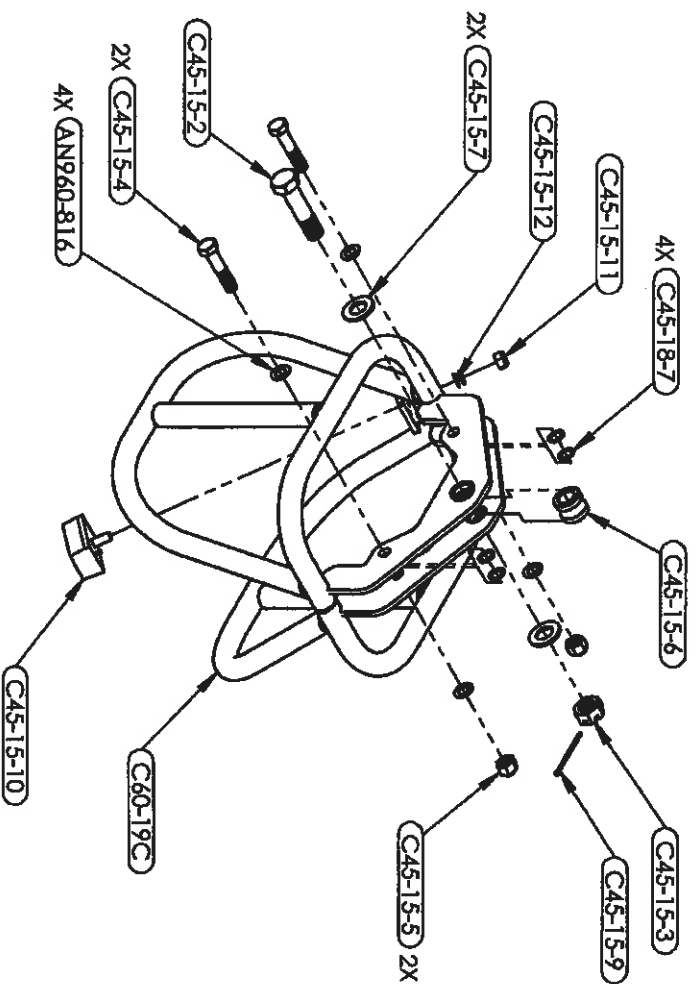
MS2104408 NUT 2 5200381

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-External Load - Issue SN	AN12H32	1	32	0
	91257A750	2	8	0
110-External Load - 2 - B4B	AN310-12	1	12	0
	C45-15-10	1	14	0
	C45-15-11	1	67	0
	C45-15-5	2	6	0
	C45-15-6	1	8	0
	C45-15-7	4	13	0
	C45-18-7	4	14	0
	C60-19C	1	1	0
	MS24665-363	1	33	0
	NAS1149C0663R	1	398	0
	NAS1149F0863P	4	640	0
Part Specifications				
Specifications could not be found.				

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
2		AS DRAWN BY APICAL.		11/6/2012	JAG	
3	15-0181	UPDATED TO NEW DRAFTING STANDARDS. CHD P/N WAS C45-15-4 IS AN960-816. C45-18-7 ADDED TO BOM QTY 4.		7/22/2015	DPD	JAG
D	15-660	Replaced B/O information for C45-15-2, C45-15-3 and C45-15-9, C45-15-12		04/12/2019	<i>ML</i>	ML



SEE ATTACHED DEVIATION

ASSY QTY	ASSY B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
		C60-19C	1	WELDMENT		
		C45-15-2	1	LIFTING BOLT	STEEL	AN12H32
		C45-15-3	1	CASTLE NUT	STEEL	AN310-12
		C45-15-4	2	CAGE BOLT	STEEL	1/2-20 X 2-1/2 GRADE 8 (MCMMASTER-CARR #91257A793)
		C45-15-5	2	CAGE BOLT NUT	STEEL	1/2-20 LOCKNUT GRADE 8 (MCMMASTER-CARR #97135A255)
		C45-15-6	1	LIFTING BUSHING	4140/4142	
		C45-15-7	2	LIFTING BOLT WASHER	STEEL	3/4 (MCMMASTER-CARR #98023AC06)
		C45-15-9	1	COTTER PIN	S.S	MS24665-363
		C45-15-10	1	FORD BUMPER		
		C45-15-11	1	CAGE BUMPER NUT	STEEL	M10, CLASS 8 (MCMMASTER-CARR #9057A1118)
		C45-15-12	1	CAGE BUMPER WASHER	STEEL	NAS1149C0668R
		C45-18-7	4	SHW	STEEL	125 X 8.511 LD. (MCMMASTER-CARR #3088A412)
		AN960-816	4	LIFTING BOLT WASHER	STEEL	AN960-816 (NAS1149F0863P)

DART Aerospace	
TITLE C60 CAGE	
DWG NO. C60-C	
SCALE 1:8	
DATE 04/12/2019	
SHEET 1 OF 1	
DRAWN BY: APICAL	
CHECKED BY: <i>ML</i>	
APPROVED BY: <i>ML</i>	
DATE: 7/22/2015	
BY: JAG	
1. BREAK ALL SHARP EDGES .015 X 45°	
2. DIMENSIONAL LIMITS APPLY AFTER FINISH	
USED ON MODEL	